Work Orde		069		*890		Page 1						
Item ID: Revision ID:	D350-591-2	14		Accept	*N900	040°	100)* Se	etup Start	IV	S1*	
Item Name:	Heli-Access-S	Step, Short RH	·						Stop	*N:	S2*	
Start Date: Required Date:	8/21/12 9/07/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item II Customer:	D:						
Reference:												
Approvals:	Process Pla	an: MLJ	Date: 12/08	21 Tooling:	Da	ite:		R	un Start Stop	I <i>Л</i>	R1*	
	QC:		Date:	SPC (Y/N):	Da	ite:			Stop	*N	R2*	
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty		Reject Number	Insp. Stamp	
Draw Nbr	Re	vision Nbr										
D3078	A											+ area
DSI 9472	. A	!							_		- <u> </u>	
*100		DOCUMENT CONTRO	DL	0.00	12/00/19		- the fire section (1989)	A	10/1	MLJ	12-9	18
DC		Memo		0.00	ኒ <i>የ</i> - '				/ -		7	
Document Control		Photocopy	bluefile and type labels a	us per PPP D350-591-214	CHG003 / D					(2	<i>)</i>	
			7									
*110 *110*		Large Fab		0.00				2	d		A	
Large Fab		Memo		0.00					$-\varphi$		19 0	(O) 7(
Large Fab				" long as per Dwg D3078 using Jig DT8680 for rive							/x · c	.ooo

											DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE			
									-		QA Closed:	Date:	
Work Ord	or.	-				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR OIU	ei.			<u>-</u> _		Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1	r	Machining	Small Fab	4	d. Eng. Coor.	Quality
						Use-as-is		1	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update	_]		Large Fab	Composite	J	Supplier	
Root					Descri	ption of work order update		Initial	Acti	on	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator							1						
Material													
Setup	Ш									:			
Other	Ш												
Process													
Supplier													
Training													
Unapproved													
						1	FAUI	LT CATE	GORY				
Landi	ng G	iear				General		_			_		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Concer	ntric to C	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	F					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/CrimpedBurrs					Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Part Moved		_
	Heat Treat Co					Countersink		Mislabe	eled		Positioned \	Wrong	
	Inspection Strip in Tube					Cut Too Short	\mapsto			Power Loss,	/Surge	Other	
	Ripples in Bend					Drill Holes		Offset		_	-		

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord August-21-12 1		9069	*89069*									Page 2	
Item ID: Revision ID:	D350-591-2	214		Accept	*N900	<u>040</u>	100)*	Setup		*NS	S1*	_
Item Name:	Heli-Access-	Step, Short RH								Stop	*N:	S2*	
Start Date:	8/21/12	Start Qty: 2.00	*2*		Cust Item	ID:							
Required Date	: 9/07/12	Req'd Qty: 2.00	*2*		Customer:								
Reference:										. .			
Approvals:	Process P	lan:	Date:	Tooling: _	D	ate:		1		Start	*NI	R1*	
	QC:			SPC (Y/N):	Date:					Stop	*NI	IR2*	
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
120 QC6- Inspect dimension		s to drawing	0.00								DAS)		
120 QC		Memo		0.00				Q)	10	3.8.	<u>38</u>	24	
Quality Control													
130				0.00								n.	
130		Large Fab						2	E	S		14	
Large Fab		Memo	8	0.00					7			12.08	2
Large Fab			for welding FWD ONL port using Jig DT8681,	Y weld Fwd End Plate as per	QSI 004 & Dwg							, ,	
		A/RAlumi	num Rod <u>/22358</u> d Plate flush/2243/	• •					į	0	Āc		
140 QC9- Inspect visual per C		QSI004- Fusion Welds	0.00					(DA	A S	8 -8 ⁶⁹ -			
1 4 0				0.00				(2) Os	10	1-08-5	9	
QC Quality Control		Memo		0.00					, ₂ 8	9			

NCR:	Yes	1	No
IVCIV.	163	/	INO

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:			Date:	₩.	•
•	٠-	¢		 	
			_		

				·					QA Closed:	Date:	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part I					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Δ	ction	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief En	g Des	scription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling	g										
Operator											
Material											
Setup											
Other								•		<u>-</u>	
Process						<i></i>	-]				
Supplier	_										
Training											
Unapproved											l
						AULT CAT	EGORY				
Landi	ng Gear			_	General				1	<u></u>	-
	Bending			_	Bend	Grain			Ovalized	<u></u>	Pressure/Forced
	—	Not Conce	ntric to	o/s _	BOM/Route	Hardv		<u> </u>	Over/Under		Temperature/Cure
	Cracks				Broken/Damaged	· ·	ction Incomplete		Part Incorred	 	Weld
'		l/Crimped		<u> </u>	Burrs	_	ctions Incomplete	e/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination						tenance	<u></u>	Part Moved		
	Heat Treat Countersink						oeled	-	Positioned V		7
	Inspection Strip in Tube Cut Too Short Ripples in Bend Cut Too Short Drill Holes					Misre			Power Loss/	Surge	Other
					Offset						
Torque Waves in Extrusion Drawing					Out of Calibration						
Turning Sequence Finish						f Sequence					
	Wave/Twist in Tube Folio					Outsid	de Dimensions				

Work Ord August-21-12 1		069		*890	169*				Page 3	\$
Item ID: Revision ID: Item Name:	D350-591-21 Heli-Access-St			Accept	*N90004	.0100	★ Setu	p Start Stop	*NS1* *NS2*	
Start Date: Required Date Reference:	8/21/12 e: 9/07/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:					
Approvals:		n:		_	Date:		Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center ID 150 *150* QC Quality Control	ID	Operation Description QC5- Inspect part compl	leteness to step on W/O	Set Up/ Run Hours 0.00 0.00	Tool ID Too	Code	Qty C		Reject Insp. Number Stamp	
*160 *160* HandFinish Hand Finishing		Chemical Conversion Co	oat per QSI005 4.1	0.00		26	QH Z	/	Il nlo	7/cd
170 *170* QC Quality Control		QC3- Inspect Part Finisl Memo	h	0.00		Ę	8 X 9 RH		- M	-Liglor

NCR: Yes	Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:											
Work Order:												
Part No.	Engineering Quality Other											
Root												
Cause	QC inspector											
occ/Data quip/Tooling Operator Material etup Other Process supplier Training Unapproved												
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend												

Out of Sequence

Outside Dimensions

DQA:

Date:

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Orde August-21-12 1.		9069		*890		Page 4					
Item ID: Revision ID: Item Name:	Revision ID:			ccept	*N900	<u>040</u>	100)* s	Setup Star Stop	I VI	S1* S2*
	quired Date: 9/07/12 Req'd Qty: 2.00		*2* *2*		Cust Item ID: Customer:						
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):	Date:		-	F	Run Star Stop		R1* R2*
Sequence ID/ Work Center II 200	D	Operation Description		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 Large Fab Large Fab		2-Bevel Aft	g Assembly as per Dwg D307 end for welding or foreign object as per QSI 02					2	\$		Az 120 M12.09. Ae 12.09.
		5-Grind End									
*210 *210* QC Quality Control		QC10- Inspect visual pe Memo	r QS1004- ground welds	0.00	s Is rhothy			- 72 . F1			

NCR:	\cdot , \cdot														
					-				•			QA Closed:	Dat	:e:	
Work Ord	er.					DISPOSITION				AGAINST I	DE	PARTMENT	PROCESS		
Part						Scrap Machining Small Fab. Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				Crosstube Small Fab Finishing Composite		Î	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	ion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Descr	iption		Date	Verification	1	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	g														
							FAU	LT CATE	GORY						·····
Landi	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short	-	Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/Unance enance	Jnclear		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Ripples in Bend					Drill Holes		Offset		·					

Out of Calibration Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		69		*89069*										
	D350-591 - 214	1		Accept	*N900	040	100)*	Setup Sta	171	S1*			
tem Name:	Heli-Access-Ste	ep, Short RH							Sto	P *N	S2*			
tart Date: Required Date:		Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item 1 Customer:									
Reference:														
Approvals:	Process Plan	1:	Date:	Tooling:	D	ate:]	Run Sta	17	R1*			
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*			
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp			
220		QC5- Inspect part compl	eteness to step on W/O	0.00										
* ??? QC Quality Control		Мето		0.00	Izlaliy			42 PH	· · ·		· · · · · · · · · · · · · · · · · · ·			
			0000541	0.00					,		mL			
*230 *230*		Chemical Conversion Co	oat per QS1005 4.1	0.00				2	18					
HandFinish		Memo		0.00			(A_{A}	φ		12/04/1			
Hand Finishing														
240 .		White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				^			Mf			
* 940 * Powdercoat Powder Coating		Memo START TIN	ME: 10 / 3 C	0.00			(XX	<i>Y</i>		12/091			
		OVEN TEN FINISH TIN	ME:	900°										
- > ((1, 1)		11 -00								***			

m121841

											DQA:	Date	·
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			
											QA Closed:	Date	:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	No.					Rework Scrap Use-as-is Work Order Update		.I Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								31,					
							FAUL	LT CATE	GORY				
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped. it n Strip in)/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/l nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
j	l I	Ripples in	Bend		1	Drill Holes	- 1	Offset					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Packaging



											DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	PDATE			
									•		QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part						Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR	No.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descri	ption of work order update		Initial	Ad	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling												,	
Operator			1										
Material								, , , ,					
Setup			ĺ										
Other '					•			٠.					
Process	П												
Supplier]						:				
Training													
Unapproved			1										
						F	AUL	T CATE	GORY				
Landi	ng (Gear				General							
Bending Bend								Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S BOM/Route							Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	—	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	-		Part Moved	_	
		Heat Trea	it			Countersink		Mislabe	led		Positioned \		
		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed:												Date	. .
													••
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part I	•					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	ł	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	T	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator		-											
Material		į											
Setup			İ									i	
Other													
Process	Ш												
Supplier													
Training	Ш												
Unapproved									,				·
							AUI	LT CATE	GORY				
Landi	Ē	ì				General	_	7		F	7	_	
	Ш	Bending				Bend	<u> </u>	Grain		<u> </u>	Ovalized		Pressure/Forced
1	Ш	Centre N	ot Concer	ntric to (D/S	BOM/Route	-	Hardwa		<u> </u>	Over/Under	<u> </u>	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged		4 '	on Incomplete		Part Incorre	⊢	Weld
	Н	Crushed/Crimped_			<u> </u>	Burrs	\vdash	┥	ions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Ш	Cuffs				Contamination	_	Mainte			Part Moved		
	-	Heat Treat				Countersink	-	Mislabe		<u> </u>	Positioned V		–
	$\vdash\vdash$	Inspection Strip in Tube				Cut Too Short	\vdash	Misread	.	L.	Power Loss/	Surge	Other
	Н	Ripples in Bend				Drill Holes	-	Offset					
	Н	Torque Waves in Extrusion				Drawing	-	-1	Calibration				
ĺ	1 1	Turning S	equence		-	Finish	1	Out of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

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Picklist Print

August-21-12 1:03:55 PM

Work Order ID:

89069

Parent Item:

D350-591-214

Parent Item Name:

Heli-Access-Step, Short RH

Start Date: 8/21/12

Required Date: 9/07/12

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:B05.10.14Modified step 10KJ/EC

IPP Rev:C 06-06-19

Added D2732-030 AS PER DSI9294 JLM Revised as per DSI9340 JLM

IPP Rev:D 10.11.15 update qty on

IPP Rev:C 06-06-27 ANA-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No	····		110	Each	52.3900	0.5	1	Ac. 12	08.1) et
Step Extrusion									(m	<u></u>	Al 12	.000	c+
				Location		Loc Qty	Lo	oc Code					
				HALL		16.37							
				469	10	2							
				644		6							
				669		7.7				· .			
				682		0.25				·			
				721	31	0.42							
				WA		26.66							
				815		2.88							
				838	94	23.78				\			
				WA013		9.36				<u>/ </u>			
				757		2							
				776	12	7.36					4.4	,	
D3063-1 Support		Manufactured	No			130	Each	42.0000	1	2		12.0	8-29
				Location		Loc Qty	<u>L</u>	oc Code					
				WA016		42							
				718	886	42				2			

NCR:	·												
											QA Closed:	Date	2:
Work Ord	er:			_		DISPOSITION	_			AGAINST DE	PARTMENT	/PROCESS	
Part NCR						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Π	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling		}											
Operator													
Material													
Setup	Г												
Other													
Process													
Supplier			1										
Training													
Unapproved]											
						F	AUL	T CATE	GORY				
Land	ing (Gear				General		_				_	
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	L	Centre N	ot Concer	ntric to O	/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/Crimped.				Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Part Moved		
	Heat Treat				Countersink		Mislabe	led		Positioned \	Wrong _		
		Inspection Strip in Tube				Cut Too Short		Misreac	I		Power Loss,	'Surge	Other
		Ripples in Bend				Drill Holes		Offset					
		Torque Waves in Extrusion				Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-21-12 1:03:55 PM

Work Order ID:	89069			,								
Parent Item:	D350-591-214							Start D	ate: 8/21/12		Required	Date: 9/07/12
Parent Item Name:	Heli-Access-Step, Sl	hort RH						Start (Qty: 2.00		Require	d Qty: 2.00
D3067-1 End Plate		Manufactured	No			130	Each	116.0000	1	2	Ri	2.08.29
				Location	<u>1</u>	Loc Qty		Loc Code				
				WA		112	!					
					78608	4	ļ					
					83855							
					84534	26)					
					86923	4:	5					
					87832	42	2		-6	2		
				WA016	***	4	ļ					
					67582	:	2					
					68214		l					
					79607		i					
D3066-1		Manufactured	No			200	Each	95.0000	2	4	1.	12.09.06
Spacer											_HL_	12.0120
				Location	<u>n</u>	Loc Qty		Loc Code			·	
				WA		9	5					
					85449	6	3		(2	2)		
					86964	2						
MS20600-AD4W4		Purchased	No			200	Each	2,546.0000	16	32		12.09.06
Rivets									·		N	12.01'0E
				Locatio	<u>n</u>	Loc Qty		Loc Code				
				321		49	8					
					121652	49	8					
				ST321		204	8					
					121011		9					
					121340	3				2		
					121444 _	200			13	2		
										-		•

NCR:	·													
											QA Closed:	Date	2:	
Work Ord	er:		-			DISPOSITION			·	AGAINST DE	PARTMENT	/PROCESS		
Part NCR	,					Rework Scrap Use-as-is Work Order Update		ľ	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
										· L.		''' 1		
Root						ption of work order update	1	Initial		tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data												ı		
Equip/Tooling	\vdash	·												
Operator	\vdash						-							
Material	H													
Setup	Н													
Other Process	H		İ											
Supplier	H													
Training	\vdash							-						
Unapproved	\vdash					•								
	1	1	1	<u> </u>	L		AUI	LT CATE	GORY		· 1	<u> </u>		
Land	ing (Gear				General						.	· · · · ·	
		Bending				Bend		Grain			Ovalized	Γ	Pressure/Forced	
		Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld	
		Crushed/Crimped.				Burrs	Г	Instruct	ions Incomplete/I	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled	
	Cuffs					Contamination	Г	Mainte	enance		Part Moved	_	_	
	Heat Treat					Countersink		Mislabe	eled		Positioned V	Vrong _		
		Inspection Strip in Tube				Cut Too Short		Misread	t		Power Loss/	Surge	Other	
		Ripples in Bend				Drill Holes		Offset						
		Torque Waves in Extrusion				Drawing	Г	Out of 0	Calibration					

Out of Sequence

Outside Dimensions

Date: ___

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-21-12 1:03:56 PM

Work Order ID: Parent Item:	89069 D350-591-214						Date: 8/21/12	Required Date: 9/07/12
Parent Item Name:	Heli-Access-Step, Short RH					Start	Qty: 2.00	Required Qty: 2.00
D3065-041 Step Leg Assembly Hi	Manufactured	No		200	Each	41.0000	18850	383 (2) Ac
•			Location	Loc Qty		Loc Code		12.09.06
			WA	11				_
			66149	0				_
			79336	1				
			83871	10				_
			WA013	30				
D3067-1	Manufactured	No		200	Each	116.0000	1	2 /12.09.06
End Plate	·						· · · · · · · · · · · · · · · · · · ·	1612.09.06
			Location	Loc Qty		Loc Code		
			WA	112				
			78608	4				_
			83855	1				_
			84534	20				_
			86923	45			<u> </u>	_
			87832	42			2	_
			WA016	4				
			67582	2			*	_
			68214	1				-
/			79607	1				
AN4-16A Bolt	Purchased	No		270	Each	121.0000	(a)	8 / 12/09/18
			Location	Loc Qty		Loc Code		
			ST357	57				No.
			122416	57				·
			ST358	64				_
			120498	14				-
			121541	50			12154	1 1
				30				\$_ T

NCR:	Yes	/ No				WORK ORDER NON-	COI	VFORM	MANCE / UPI	DATE	QA Closed:	Date	
Work Ord	er:					DISPOSITION				AGAINST DE			
Part I NCR I						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
l and:		·			•		AUL	T CATE	GORY				· · · · · · · · · · · · · · · · · · ·
Landi	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/U nance iled	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	et ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
l	L	Trorque W	raves in E	.xนานราชท	1	lniamiilk	1	Jour of C	Landration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-21-12 1:03:56 PM

Work Order ID: Parent Item: Parent Item Name:

89069

D350-591-214

Heli-Access-Step, Short RH

Start Date: 8/21/12

Required Date: 9/07/12

Start Qty: 2.00

Required Qty: 2.00

Rubber Extrusion

NAS1149D0463J

Manufactured Manufactured

Purchased

No

No

No

No

No

Location

Location

ST351

122416

116289

119097

ST353

Location Loc Qty ST410 370.0394684 70987

0.3 83560 369.739468 270

270

Loc Qty

Loc Oty

270

29 8

21

Each

270

94

94

f

Each

Each

94.0000

Loc Code

Loc Code

Loc Code

180.0000

166.0000

Loc Code

370.0395

Purchased

Purchased

Manufactured

Loc Code Location Loc Oty ST356 166 120731 100 121243 50 121708 16 270

29.0000 Each

Loc Qty Location ST470 89026 ST472 176 84134 176

NCR:	,												
											QA Closed:	Date:	
Work Orde	er.				ļ	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part NCR N	- _ No.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty		tion of work order update or Non-conformance	1	Initial nief Eng	Act	ion	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		Date	Step	Q		or won-comormance	CII	ilei Liig	Desci	іриоп	Date	Verification	QC IIISPECIOI
							AUL	T CATE	GORY				
Landi	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				D/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/Unance Iled	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss,	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	⊢					=	_	4					Ot

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-21-12 1:03:56 PM

Work Order ID: Parent Item:	89069 D350-591-214							Start I	Date: 8/21/12	2	Required Date:	9/07/12
Parent Item Name:	Heli-Access-Step, S	hort RH							Qty: 2.00		Required Qty:	
D2856-400 @ Factor	لعما	Manufactured	No			270	f	183.1994	0.6	1.2	-1.A	186
Abrasion Strip	2/01/18			Location	n	Loc Qty		Loc Code				
×C -/-	-12/01/12			ST403	<u>-</u>	78.998						
_				51705	81875	78.998			81	875		
				ST409	01075	104.2014						
				31409	63735	0.6696						
					68076	0.3149						
					71164	8.46						
					86905	94.7569						
MS21042L3 Nut		Purchased	No			270	Each	3,235.0000	2	4	128	
4				Locatio	<u>n</u>	Loc Qty		Loc Code			I	-
2				316		795						
					122452	795						
				ST300		728						
					117885	32						
					119017	558						
1					119075	138						
				ST317		1712						
					122141	1712			12	2141		
AN4-13A Bolt		Purchased	No			270	Each	1,115.0000	12	2808	13	12/09/18
				<u>Locatio</u>	<u>n</u>	Loc Qty		Loc Code				
				ST356		500						•
					122416	500						
				ST357		615						
					120187	19						
					120770	12						
					121652	582						
					122063	2						

							DQA:	Date			
NCR:	Yes / No)			WORK ORDER NON-C	CONFO	RMANCE / U	PDATE	QA Closed:	Date	
					DISPOSITION			AGAINST DE			
Work Ord	er:				DISPOSITION	.		AGAINST DE	:PANTIVIENT	/PROCE33	
Part I		_			Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	₹	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	<i>I</i>	Action	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Er	g De	scription	Date	Verification	QC Inspector
Doc/Data								1100			
Equip/Tooling											
Operator				•							
Material										:	
Setup											!
Other											
Process	П										
Supplier	П										
Training											
Unapproved											
					F	AULT CAT	EGORY		•		
Landi	ng Gear	•			General						
	Bendin	3			Bend	Grain	1		Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to (o/s	BOM/Route	Hardy	vare		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ction Incomplete]	Part Incorre	ect	Weld
	Crushe	d/Crimped	-		Burrs		ctions Incomplet		 Part Lost/M	<u> </u>	Wrong Stock Pulled
	Cuffs	•			Contamination	\vdash	tenance		Part Moved		
	Heat Tr	eat			Countersink	Misla			Positioned \		
	\vdash	ion Strip in	Tube		Cut Too Short	Misre			Power Loss,		Other
		in Bend		<u> </u>	Drill Holes	Offse		L		J	

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-21-12 1:03:56 PM

Work Order ID:

89069

Parent Item:

D350-591-214

Parent Item Name:

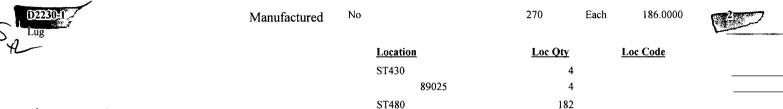
Heli-Access-Step, Short RH

Start Date: 8/21/12

Required Date: 9/07/12

Start Qty: 2.00

Required Qty: 2.00



No Purchased

ST480 84136

270

Each 5,025.0000

Locatio	<u>n</u>	Loc Oty		Loc Code
314		4928		
	122452	4928		
ST300		97		
	121011	2		
	121444	95		
		270	Each	0.0000

182



NAS1149D0363J

Purchased

No

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE				
											QA Closed:	Date		
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part I	- No					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root						ption of work order update	1	Initial Action			Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Descrip	otion	Date	Verification	QC Inspector	
Doc/Data	Н													
Equip/Tooling	Н													
Operator		4												
Material	Н	4												
Setup	Н	4												
Other	\vdash													
Process	\vdash						1							
Supplier Training	Н						1							
Unapproved	Н	:					ł							
опарргочес	Щ		<u>[</u>	l	L		ΔШ	T CATE	SORY		<u> </u>	<u>i</u>		
Landi	ng G	ear	• • •			General		- CATE						
	$\overline{}$	Bending				Bend	Г	Grain			Ovalized		Pressure/Forced	
	${f H}$	Centre No	t Concer	ntric to	o/s	BOM/Route		Hardware			Over/Under	tolerance	Temperature/Cure	
	Cracks					Broken/Damaged		1	on Incomplete	-	Part Incorre	 	Weld	
	Crushed/Crimped.					Burrs		Instructions Incomplete/Unclear		nclear	Part Lost/Missing		Wrong Stock Pulled	
	-	Cuffs	•			Contamination		Mainte	•	<u> </u>	Part Moved	<u> </u>		
		Heat Trea	t			Countersink		Mislabe			Positioned \			
		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss,	_	Other	
	Ripples in Bend					Drill Holes		Offset			-	· L		

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

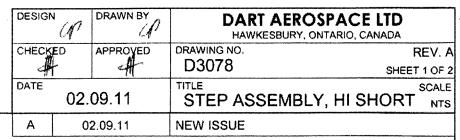
Drawing

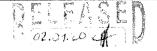
Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G









Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	-042
D3078-042	Step Assembly, High Short (RH)		Х
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SCBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO __8206_2//03.





CHECKED DATE 02.09.11

APPROVED

DRAWING NO.

REV. A

SHEET 2 OF 2

1:20

HI SHORT

ASSEMBLY,

1.00

DRAWN BY

DESIGN

STEP

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA

02.07.20





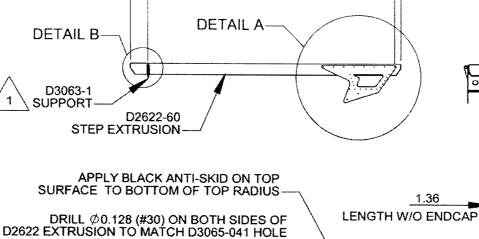


Pol

0.65

35.1° (TYP)

DETAIL A (1:5)



PATTERN. RIVET D3065-041 TO D2622 USING MS20600AD4W4 RIVET (16 PLACES)

D3066-1 SPACER

(2 PLACES)

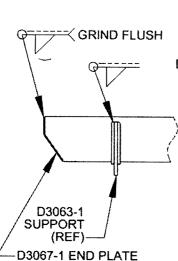
D3065-041

LEG ASSEMBLY

59.75 (WITHOUT ENDPLATES)

TO AFT FACE OF D3063-1)

54.56 (DIST. FROM 1ST HOLE



(2 PLACES)

DETAIL B (1:5)

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HZ HZ

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER AND

INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6 REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step ™, Short Step - High Skid, LH
	Х			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step ™, Short Step - Low Skid, LH
			Х	D350-591-216	Heli-Access-Step ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

89069

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

3Y: D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

Α	NEW ISS	UE		RF	09.08.05			
REV.			DESCRIPTION	BY	DATE			
DESIGN (DART AEROSPACE LTD					
DRAWN		RF	HAWKESBURY, ONTARIO, CANADA					
CHECKED		ul	DRAWING NO.		REV. A			
MFG. AF	PPR.	NA	DSI 9472	\$	SHEET 1 OF 2			
APPRO\	/ED	M	TITLE		SCALE			
DE APPR.			BOLT ADDITION NTS					
DATE	09.08	.05	COPYRIGHT © 2009 BY DAR THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SU NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COM WITHER PERMISSION ERROW AS	PPLIED ON THE EXPRE	SS CONDITION THAT IT IS			

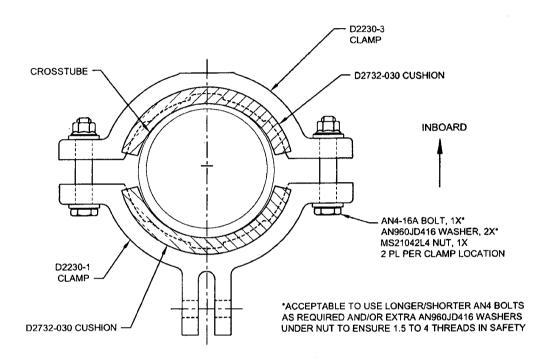


FIGURE 1: CLAMP DETAIL OPTIONAL CLAMP CONFIGURATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # §1-0-01

APPROVED

D. SHEPHERD (DE # 02)

DATE: 09.08.05 CERT. NO.: SH92-6 ISSUE NO.: 11



DESIGN	9	DART AEROSPACE LTD					
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA					
CHECKED	4	DRAWING NO.	REV. A				
MFG. APPR.	NA	DSI 9472	SHEET 2 OF 2				
APPROVED	W	TITLE	SCALE				
DE APPR.	-#-	BOLT ADDITION	NTS				
DATE 09.0	08.05	COPYRIGHT © 2009 BY DAR THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUP NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COM- WRITTEN PERMISSION FROM DAF	PPLIED ON THE EXPRESS CONDITION THAT IT IS MUNICATED TO ANY OTHER PERSON WITHOUT				

DART AEROSPACE LTD.

REFERENCE ONLY

D350-591 Page 23 of 23

Qty -211	Qty -212	Qty -213	S Qty /	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description	
-211 X	-414	-213	-2 jet	410		<u> </u>		D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH	
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH	
		х						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH	
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH	
			 ^ -	Х				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH	
			 	^_	х			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH	
			 		^	Х		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH	
							Х	D350-591-312	Heli-Access-Step™, Long Step - High Skid, RH	
			 				_ ^	2000 001 012		
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)	
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)	
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)	
			1 1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)	
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)	
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)	
		_	 			1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)	
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)	
4	4							D2182B035	RUBBER CUSHION	
		2	2	2	2			D2230-1	MOUNTING LUG	
		2	7 2	2	2==	- 04	-4°	D2230-3	MOUNTING LUG	
8	8		4		===			D2274	RADIUS BLOCK	
						2	2	D2618	BUSHING	
4	4	4	/4-	4	-4		9 mg - 40.	D2732-030	CUSHION	
- 2	2	1	i i	1	1	2	. 2	D2856-400-720	ABRASION STRIP	
2	2	<u> </u>	- C					D3064-1	CLAMP	
1	1							D3079-041	SUPPORT ASSEMBLY	
-	4							D3080-1	CLAMP	
	- 7		 			2	2	D3235-1	MOUNTING LUG	
						1	1	D3278-041	SUPPORT ASSEMBLY	
		<u> </u>	 							
2	2	2	1 2	2	2	2	2	AN3-35A	BOLT	
10	10	2	2	2	2			AN4-11A 7	BOLT	
		4	4	4	4	8	8	AN4-13A	BOLT	
						2	2	AN5-36A	BOLT	
4	4	4	4	4	4	4	4	AN960JD10	-WASHER	
20	20	12	7 12	12	12.	16	16	_AN960JD416	WASHER	
			To any complete the	19		4	4	AN960JD516	WASHER	
2	2	2	7-2-	2	2	2	2	-MS21042L3	NUT	
10	10	6	6	6	6	8 .	8	_MS21042L4 /	NUT	
			1		I	2	2	MS21042L5	NUT	
						1	1	*DSI 9410-011	STEP MODIFICATION KIT	

^{*}DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER AND

INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6 REF FAA STC: SH967NE



For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213			Part Number	Description	
X				D350-591-213	Heli-Access-Step ™, Short Step - High Skid, LH
	X			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
	1	Х		D350-591-215	Heli-Access-Step ™, Short Step - Low Skid, LH
			X	D350-591-216	Heli-Access-Step ™, Short Step - Low Skid, RH
4	4	4	4	TAN4116A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

BY: D. SHEPHERD (DE # 02)

DATE: 09.08.05 CERT. NO.: SH92-6 ISSUE NO.: 11

Α	NEW IS	SUE	RF	09.08.05				
REV.			DESCRIPTION	BY	DATE			
DESIGN		97	DART AEROSPACE LTD					
DRAWN		RF	HAWKESBURY, ONTAR	ITARIO, CANADA				
CHECKED		ul	DRAWING NO.	REV. A				
MFG. AF	PR.	NVA	DSI 9472	SHEET 1 OF 2				
APPRO	VED	M	TITLE		SCALE			
DE APPR.			BOLT ADDITION NTS					
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